

3/16/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

Job Set #43



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

MAR 15 2018

D350-567-141
Job Sheet 174469



Part No: D350-567-141

Job Qty: 2 ea

Part Name: Floor Window Close Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/16/18

Job Tracking No:

Due Date: 4/11/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER ECN12-511 DD
VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER DSI9590
REV:E DD VERF:JLM IPP REV :E AS PER DSI9590 REV F JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/11/18	4/11/18	0.00	0.00	Start Up Stores/Pkg-2	9-E	APR 19 2018
110	Packaging	2 pcs	4/11/18	4/11/18	0.00	0.00	Packaging1-3	9-E	APR 19 2018
120	QC	2 pcs	4/11/18	4/11/18	0.00	0.00	QC4	9-E	7.10.
125	DC	2 pcs	4/11/18	4/11/18	0.00	0.00	DC	9-E	7.10.
130	Packaging	2 pcs	4/11/18	4/11/18	0.00	0.00	Packaging3-1	9-E	7.10.
140	QC21-FG	2 Ea	4/11/18	4/11/18	0.00	0.00	QC21	9-E	APR 20 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D350-567-141 CHG004

Descriptions: 130 - Identify and pack for shipping as per PPP D350-567-141 Location:FG033

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	14 Ea (7 ea)	90-Start up Operation	501568
AN525-10R6	Screw	4 Ea (2 ea)	90-Start up Operation	50157307
AN525-832R7	Screw	4 Ea (2 ea)	90-Start up Operation	5014745
D3802-1	Window Seal (\$ Per Foot)	4 Ea (2 ea)	90-Start up Operation	5001843 x 1 P1649731
D4434-041	Fwd Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5060285
D4434-047	Cover Assembly	2 Ea (1 ea)	90-Start up Operation	5061225
D4435-045	T/R Bellcrank Cover Assembly	2 Ea (1 ea)	90-Start up Operation	5022224
D4435-9	Bracket	4 Ea (2 ea)	90-Start up Operation	5054124
D4436-041	Aft Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5057415
D4441-1	Rubber Seal	4 Ea (2 ea)	90-Start up Operation	50151347
MS21042L06	Nut	14 Ea (7 ea)	90-Start up Operation	5019379
MS21042L08	Nut	4 Ea (2 ea)	90-Start up Operation	50414234
MS21042L3	Nut	10 Ea (5 ea)	90-Start up Operation	5038764
MS21059L3	Nut Plate	4 Ea (2 ea)	90-Start up Operation	5052668
MS35206-229	Screw	14 Ea (7 ea)	90-Start up Operation	50135603
NAS1149F0332P	Washer	24 Ea (12 ea)	90-Start up Operation	5020603 M1357 09-229
NAS1149FN616P	Washer	28 Ea (14 ea)	90-Start up Operation	5019371
NAS1149FN816P	Washer	4 Ea (2 ea)	90-Start up Operation	50117316-25



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Container No: S063068



Part: D350-567-141

Job No: 174469

Serial No/Batch: S063068

Revision:

Inspector:

Date: 04/19/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	14	222	0
	AN525-10R6	4	268	0
	AN525-832R7	4	72	0
	D3802-1	4	70	0
	D4434-041	2	1	0
	D4434-047	2	3	0
	D4435-045	2	3	0
	D4435-9	4	4	0
	D4436-041	2	0	0
	D4441-1	4	155	0
	MS21042L06	14	419	0
	MS21042L08	4	2,667	0
	MS21042L3	10	2,865	0
	MS21059L3	4	161	0
	MS35206-229	14	60	0
	NAS1149F0332P	24	2,721	0
	NAS1149FN616P	28	121	0
	NAS1149FN816P	4	252	0

Part Specifications

Specifications could not be found.

Plex 3/16/18 8:02 AM Dart.Gagnon.Michelle



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002276	S058688	AN3-3A	Bolt	S015688	ST350	14
002276	S058687	AN525-10R6	Screw	FM137307	ST329	4
002276	S058686	AN525-832R7	Screw	S014745	ST328	4
002276	F164973	D3802-1	Window Seal (\$ Per Foot)		ST416	2
002276	S001843	D3802-1	Window Seal (\$ Per Foot)	S001383	ST416	2
002276	S058685	D4435-045	T/R Bellcrank Cover Assembly	S022224	ST620	2
002276	S058684	D4435-9	Bracket	S054124	ST091	4
002276	S058683	D4441-1	Rubber Seal	F151347	ST422	4
002276	S058682	MS21042L06	Nut	S019379	ST303	14
002276	S058681	MS21042L08	Nut	S044234	ST303	4
002276	S058680	MS21042L3	Nut	S038764	ST303	10
002276	S058679	MS21059L3	Nut Plate	S052668	FG027	4
002276	S058678	MS35206-229	Screw	FM135603	ST271	14
002276	S058677	NAS1149F0332P	Washer	M133709-272	ST262	24
002276	S058676	NAS1149FN616P	Washer	S019371	ST264	28
002276	S058675	NAS1149FN816P	Washer	F117316-25	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/6/18 7:53 AM dart.quirion.sonia

Change Record

PAGE 1 OF 1

Part Number: D350-567-141

Description: FLOOR WINDOW CLOSEOUT

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)



3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-k-g	1.66 m	2.94 m-k-g

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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